

Derev 57000

Work Order ID 52351

Tuesday, September 22, 2009 12:26:42 PM



Page 1

Item ID: D3021-041
Revision ID: A
Item Name: Tube Assembly

Accept



Setup Start



Stop



Start Date: 9/23/2009 Start Qty: 3.00
Required Date: 10/9/2009 Req'd Qty: 3.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: *RL ml*
QC: _____

Date: *09-9-22*

Tooling: _____

Date: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3021	Rev A

100



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1-Cut tube as per Dwg D3021

2-Drill tube as per Dwg D3021 using D8622

3-Deburr

4-Weld as per Dwg D3021 QSI004

A/R 4130 Rod Batch: *M1075*

EL 9-9-24

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

BE 10/23/10

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Page 2

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Accept



Setup Start



Stop



Start Date: 9/23/2009 Start Qty: 3.00
Required Date: 10/9/2009 Req'd Qty: 3.00



Cust Item ID:
Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/10/10

XL

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:00am
OVEN TEMPERATURE: 320°F
FINISH TIME: 10:30am

=> 10/03/11

XL

Ø

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/03/11

Ø

Ø

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Item ID: D3021-041

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Item Name: Tube Assembly

Start Date: 9/23/2009 Start Qty: 3.00

Required Date: 10/9/2009 Req'd Qty: 3.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: G-A

0.00



Packaging

Memo

0.00

Packaging

950/03/16 ①

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/17 *[Signature]*
MF
10-3-16

Picklist Print

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Page 1

Work Order ID: 52351

Parent Item: D3021-041RevA

Parent Item Name: Tube Assembly

Comments:

Start Date: 9/23/2009

Required Date: 10/9/2009

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3017-11RevA cap		Manufactured	No			100	Each	12.0000	6.0000			



EL 10-3-9

B52583 x 2

M4130NT0.750W.049

Purchased

4130 RD Tube .750 x.049W



No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

44779

12

12

100

f

167.5700

6.5788



EL 10-3-9

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

167.57

10133

12.75

103012

3

10498

0.04

110740

127.01

11105

24.77

35

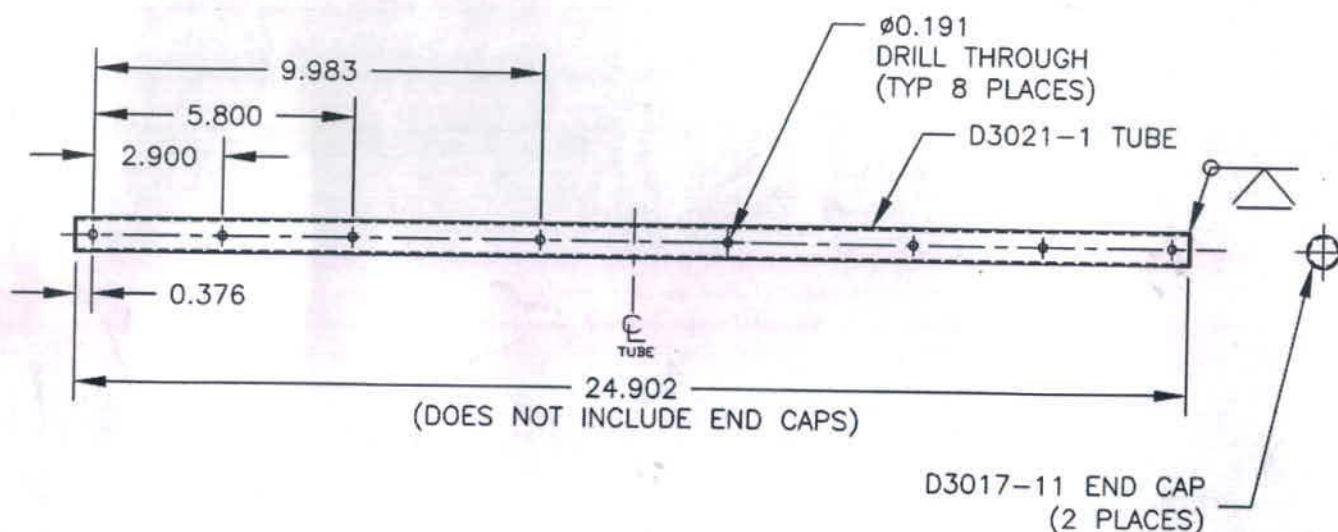
2-081

DART



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3021	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE TUBE ASSEMBLY	SCALE 1:4
A	01.05.18	NEW ISSUE	

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52351



D3021-041 TUBE ASSEMBLY
(D3021-1 TUBE)

NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) MATERIAL: AISI 4130 TUBE, $\phi 0.75$ DIA x 0.049 WALL (M4130N-T0750W049)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

RELEASED
01.05.30

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